



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3492-045
Job Sheet 170274



Part No: D3492-045

Job Qty: 60 ea

Part Name: Plug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E IPP Rev: A 06.03.21 New Issue JLM IPP Rev: B 06-08-28 As per Rev B JLM IPP Rev: C 07-12-06
as per rev c DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-2		FK 18-2-8
100	Hardinge	60 pcs	1/25/18	1/25/18	0.00	4.25	Hardinge		FK
110	QC	60 pcs	1/25/18	1/25/18	0.00	0.00	QC2 Machining-2		FK
120	QC	60 pcs	1/25/18	1/25/18	0.00	0.00	QC8 Machining-2		FK 18/02/09
130	Small Fab	60 pcs	1/25/18	1/25/18	0.00	1.37	Small Fab-4		DAS
140	QC	60 pcs	1/25/18	1/25/18	0.00	0.00	QC5		38
150	HandFinish	60 pcs	1/25/18	1/25/18	0.00	0.48	HandFinish1		18-02-12
160	Powdercoat	60 pcs	1/26/18	1/26/18	0.00	0.69	Powdercoat1		18-02-28
170	QC	60 pcs	1/26/18	1/26/18	0.00	0.00	QC3		11
180	Packaging	60 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-1	FP001	BEB 18-03-01
190	QC21-SA	60 Ea	1/26/18	1/26/18	0.00	0.00	QC21		18/03/01

Part Op 100 - 1-Turn as per Folio FA634 & Dwg D3492 Dwg Rev: _____ Folio Rev: _____

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1-Deburr if necessary 2-Tumble

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - (Flat End Only) START TIME: 4:45 OVEN TEMPERATURE: 320° FINISH TIME: 5:15.

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job Allocations

Job Allocations could not be found.

operation
90 - Start up Operation

component part M6061 T6 B0.375

Part Specifications

S025753 3.919' 0006153

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																					
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Sk Ma Thermof Lai QT																																					
NCR No. _____		Date: _____		Step #: _____																																					
Description Work Order Deviation																																									
Root Cause <table border="0" style="width: 100%;"> <tr> <td style="width: 33%;">Environment ☐</td> <td style="width: 33%;">No Re-verification ☐</td> <td style="width: 33%;">Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table> Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam ☐ Inspection Ir ☐ Contaminati ☐ Countersink ☐ Cut Too Shor ☐ Instructions l ☐ Drill Holes ☐						Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	
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Past Expiry Date ☐	Manufacturing Process ☐																																								
Misidentified ☐	Past Due ☐																																								
OTHER : Misaligned/off center ☐ Turning Sequence ☐																																									

Part NO: D3492-045
Original Serial #: S040473
Revision:
Operation:
Change No:

Start up Operation 02/08/18
Job No: 170274



Reengineering ☐
 Quality ☐
 Other ☐
 042) Approval

Deleted By

/ Supervisor
 Verification

Coordinator
 Approval

ed Wrong
 Dimensions
 der tolerance
 rrect
 /Missing
 red

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INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	